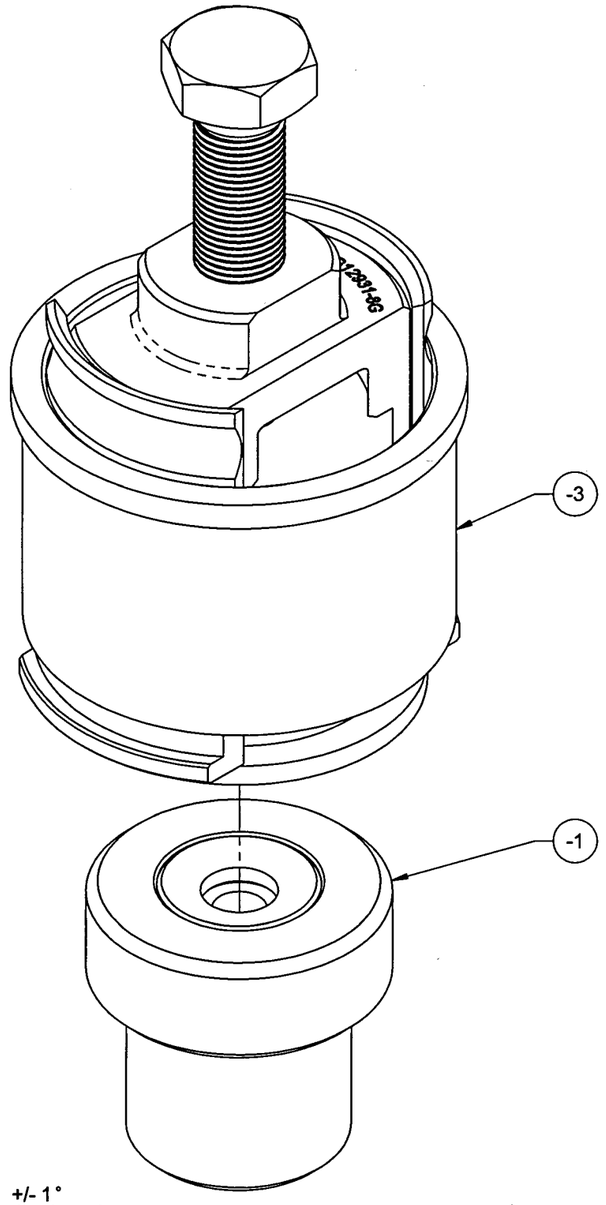
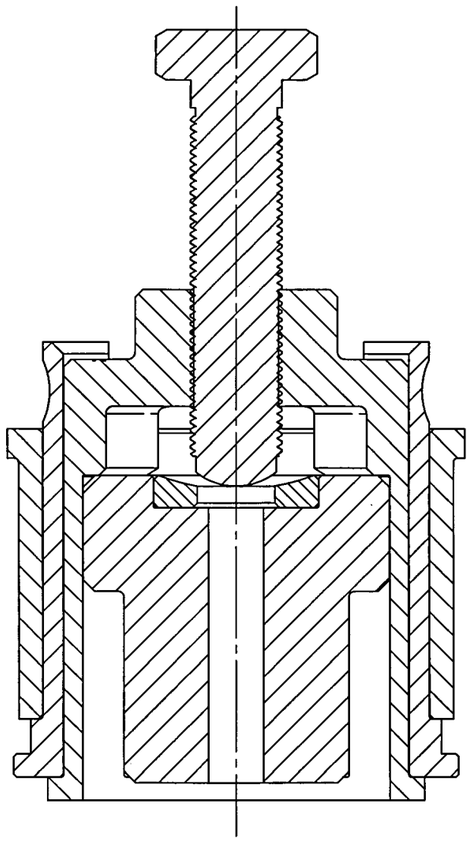
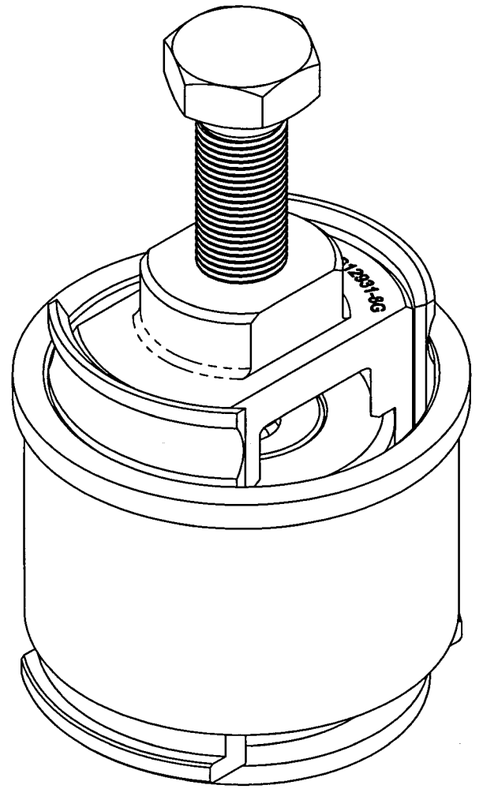
ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6320G12931-8G-1	REACTION ASSY
-3	1	RBW6320G12931-8G-3	EXTRACTOR ASSY







RBW6320G12931-8G MGB INPUT / GIMBAL REMOVAL PULLER

9

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ASSEMBLE AS SHOWN
9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

REV.	DESCRIPTION	ECN #	BY
A	NEW ISSUE	18-551	VM

DESIGN	VM
DRAWN	VM
CHECKED	ML
MFG. APPR.	DP
APPROVED	VM
DATE	8/28/2018

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART # RBW6320G12931-8G REV. A
SHEET 1 OF 8

TITLE MGB INPUT / GIMBAL REMOVAL PULLER SCALE NTS

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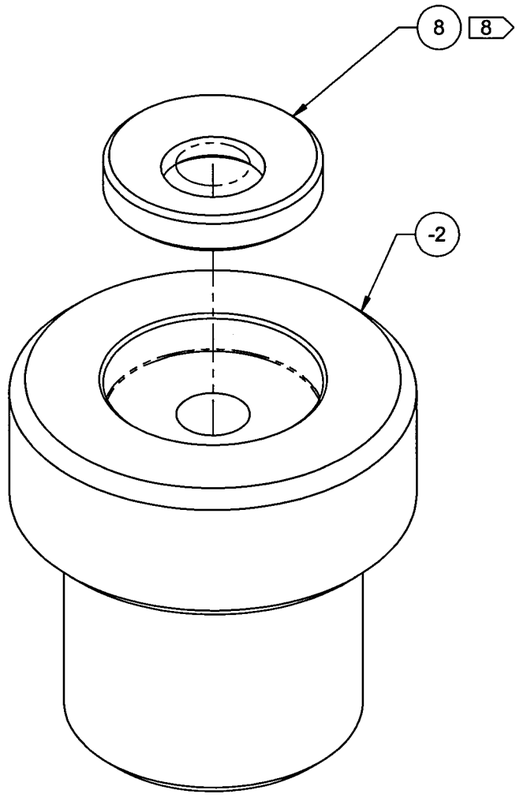
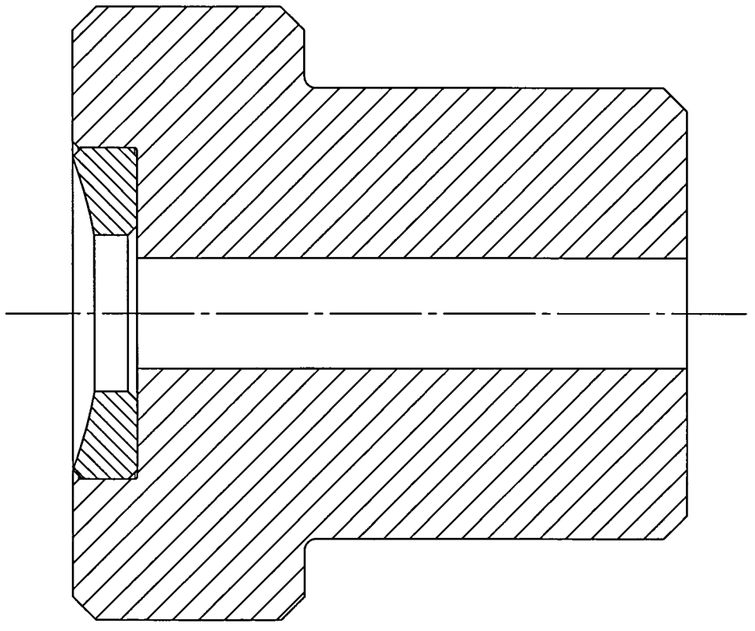
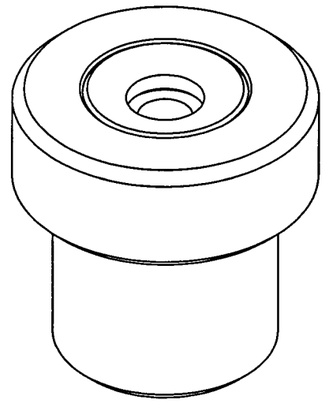
ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6320G12931-8G-2	REACTION
8	1	McMaster#91944A403 or EQUIV.	SPHERICAL WASHER FOR 1/2" SCREW







RBW6320G12931-8G-1 REACTION ASSY

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ASSEMBLE AS SHOWN,
9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 8 WITH ITEM -2 AND REMOVE EXCESS

DESIGN	VM
DRAWN	VM
CHECKED	ML
MFG. APPR.	DP
APPROVED	VM
DATE	8/28/2018

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART # RBW6320G12931-8G REV. A
SHEET 2 OF 8

TITLE MGB INPUT / GIMBAL REMOVAL PULLER SCALE NTS

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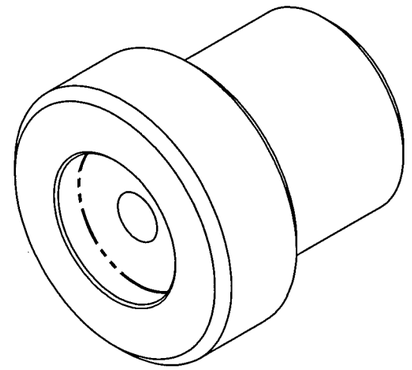
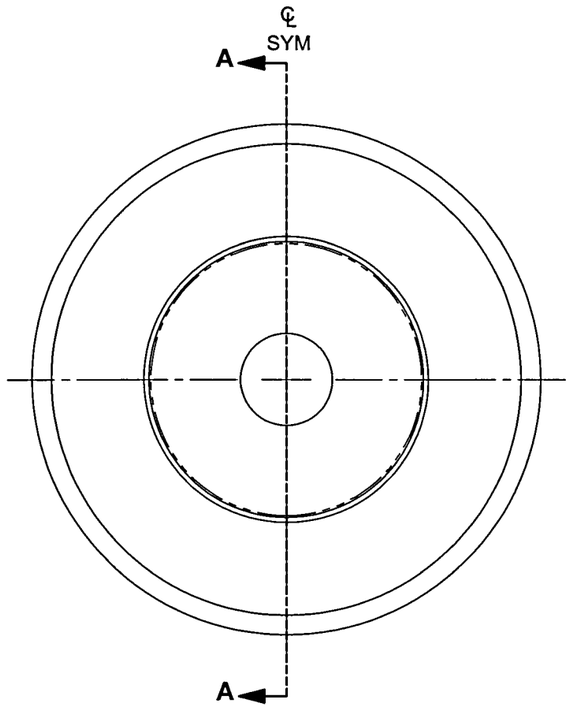
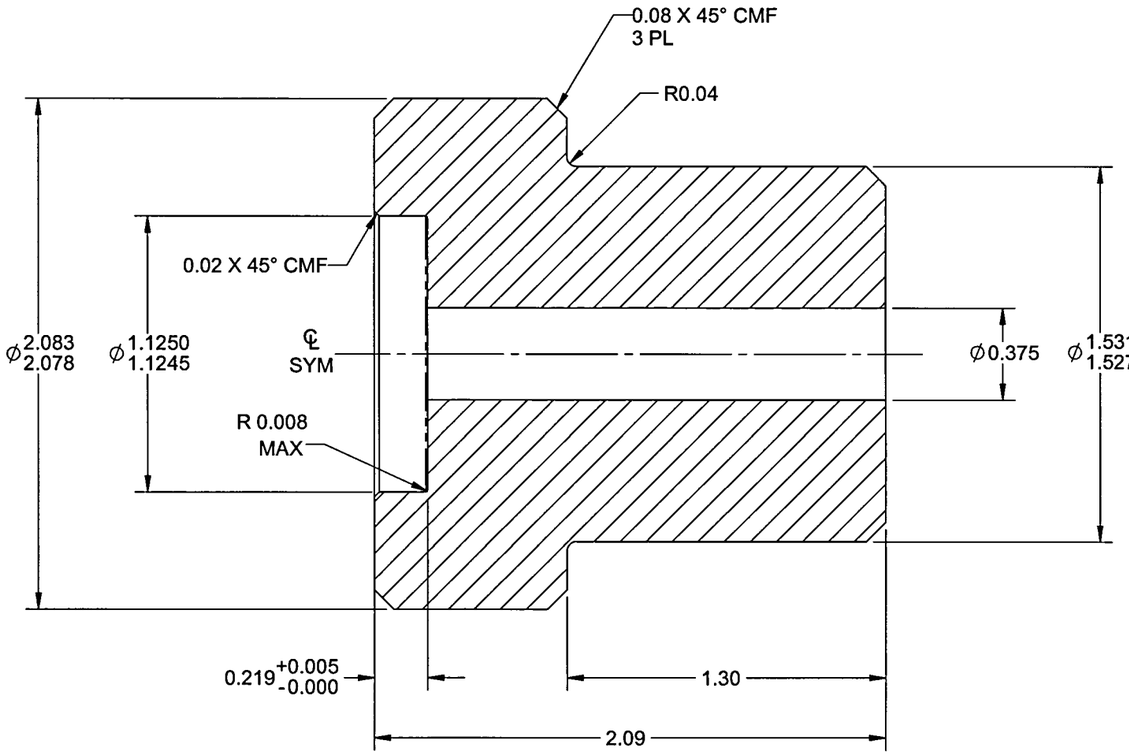




RBW6320G12931-8G-2 REACTION



SECTION A-A

NOTES:
1) MATERIAL: 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	VM
DRAWN	VM
CHECKED	ML
MFG. APPR.	DP
APPROVED	VM
DATE	8/28/2018

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART # RBW6320G12931-8G
REV. A
SHEET 3 OF 8

TITLE
MGB INPUT / GIMBAL REMOVAL PULLER
SCALE NTS

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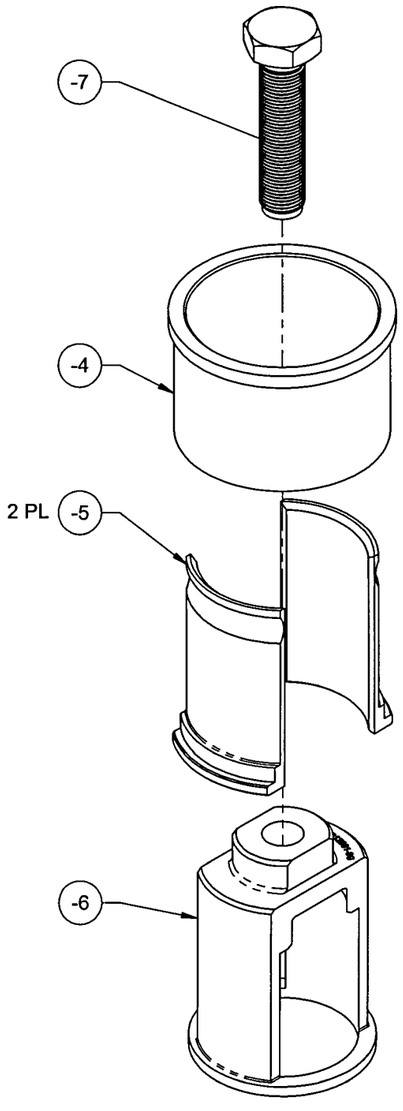
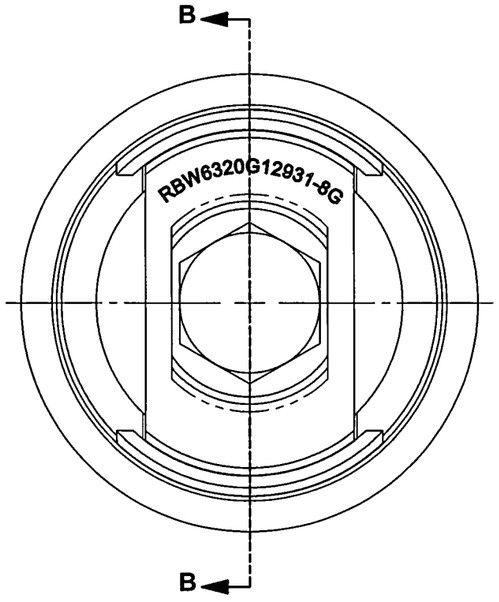
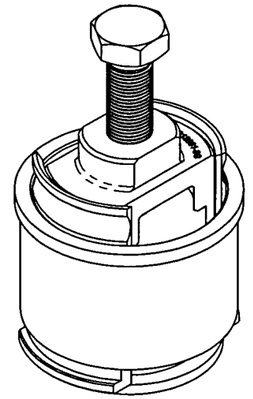
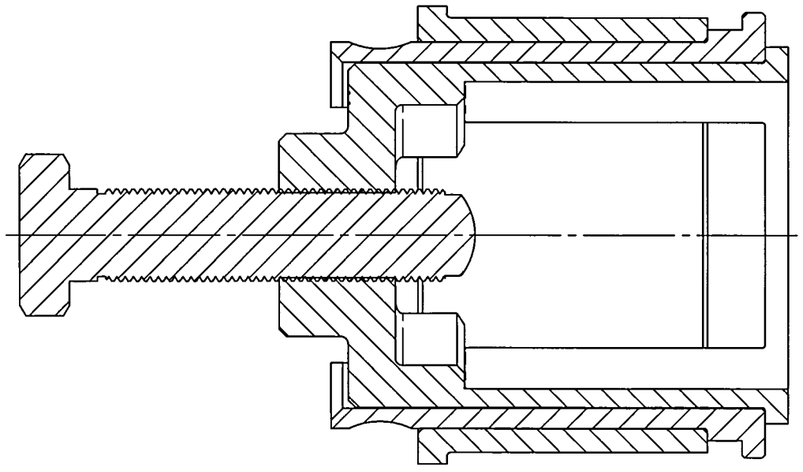
ITEM #	QTY	PART #	PART TITLE
-4	1	RBW6320G12931-8G-4	GUIDE
-5	2	RBW6320G12931-8G-5	HALF EXTRACTOR
-6	1	RBW6320G12931-8G-6	EXTRACTOR BODY
-7	1	RBW6320G12931-8G-7	SPECIAL BOLT





RBW6320G12931-8G-3 EXTRACTOR ASSY





SECTION B-B

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ASSEMBLE AS SHOWN

DESIGN	VM
DRAWN	VM
CHECKED	ML
MFG. APPR.	DP
APPROVED	VM
DATE	8/28/2018

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART # RBW6320G12931-8G
REV. A
SHEET 4 OF 8

TITLE
MGB INPUT / GIMBAL REMOVAL PULLER
SCALE NTS

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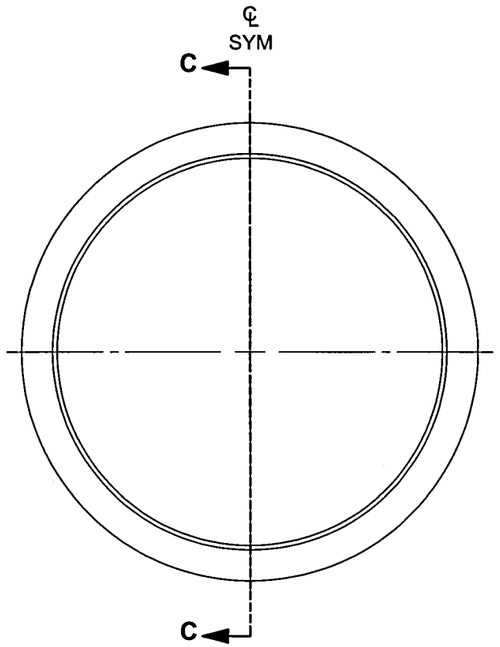
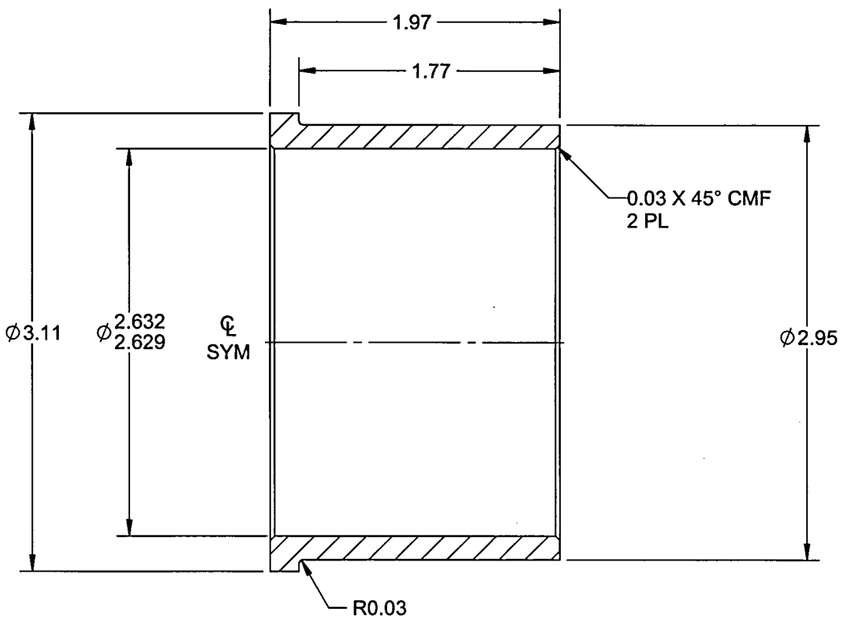
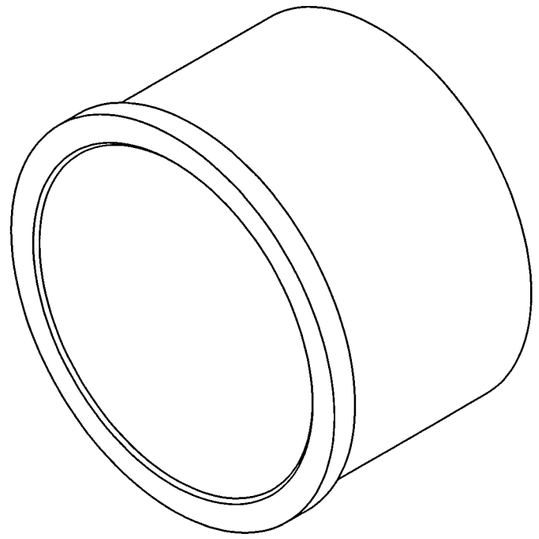


RBW6320G12931-8G-4 GUIDE



SECTION C-C



NOTES:
1) MATERIAL: 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	VM	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	VM	
CHECKED	ML	TOOL PART # RBW6320G12931-8G REV. A SHEET 5 OF 8
MFG. APPR.	DP	
APPROVED		TITLE MGB INPUT / GIMBAL REMOVAL PULLER SCALE NTS
DATE	8/28/2018	

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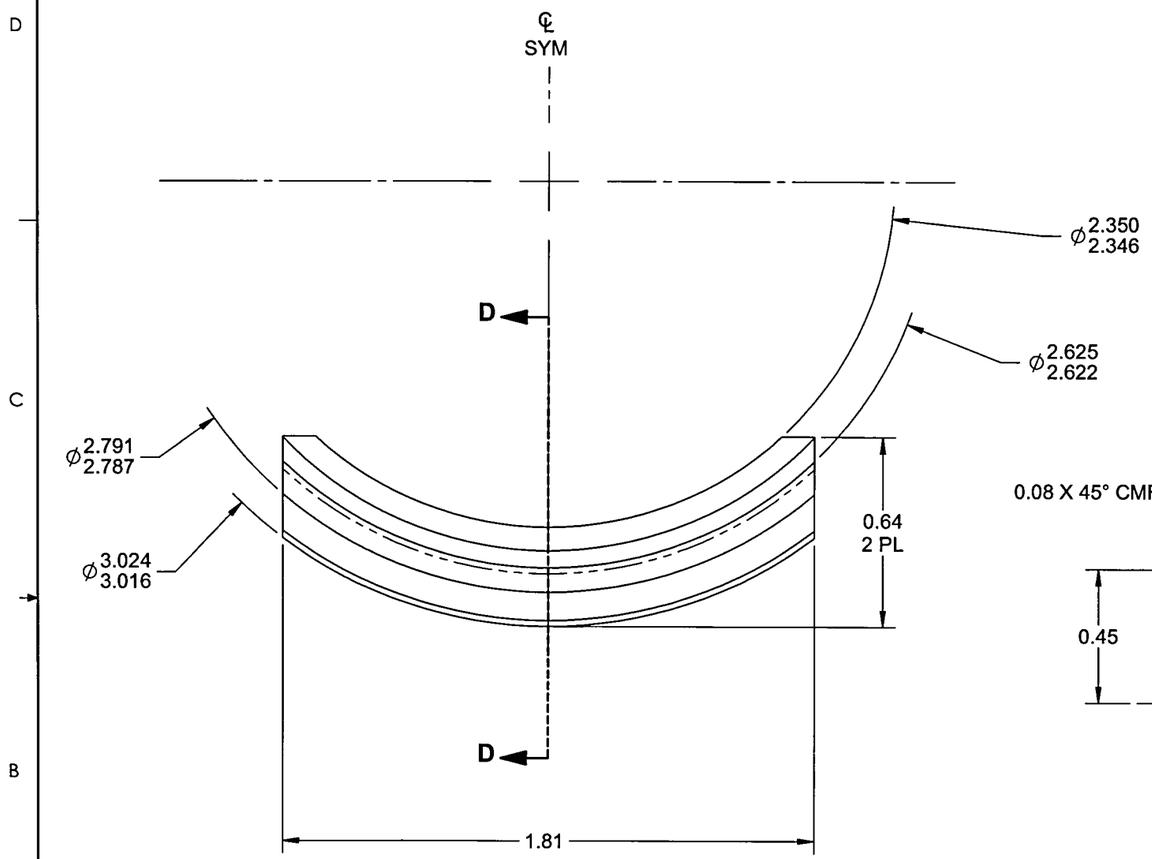
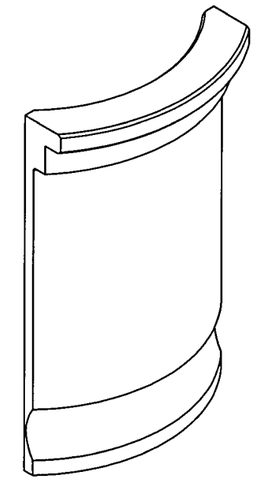
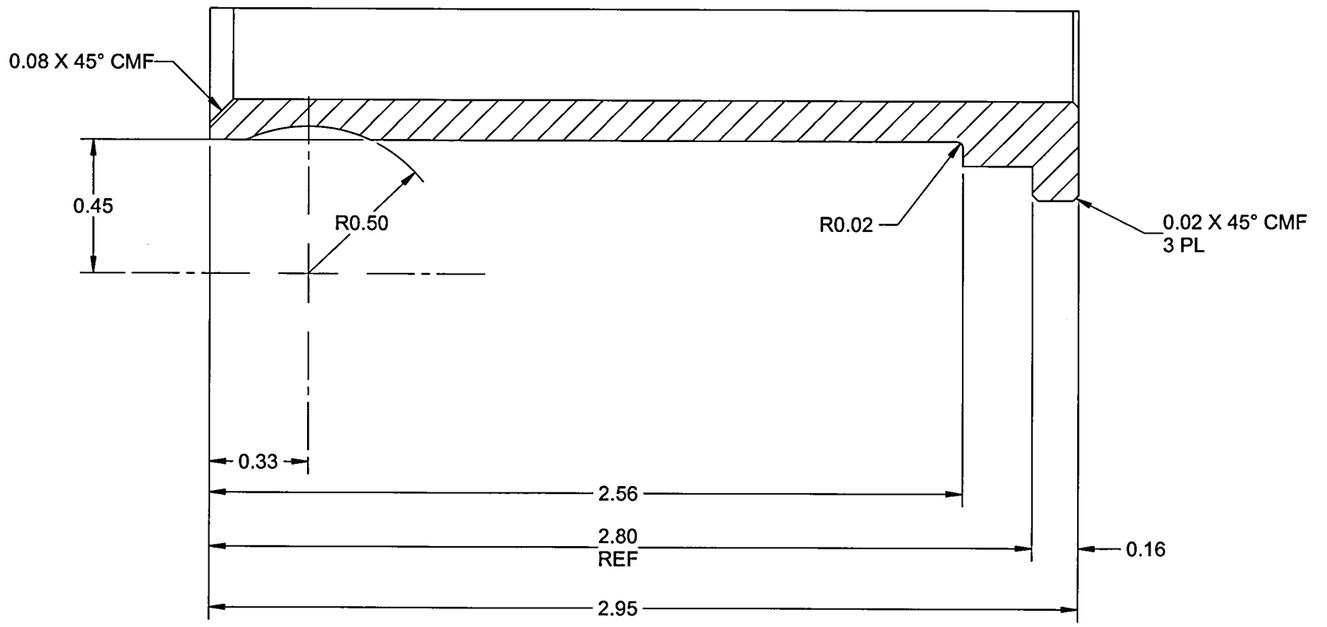


RBW6320G12931-8G-5 HALF EXTRACTOR





SECTION D-D

NOTES:
1) MATERIAL: 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	VM
DRAWN	VM
CHECKED	ML
MFG. APPR.	DP
APPROVED	VM
DATE	8/28/2018

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART # RBW6320G12931-8G REV. A
SHEET 6 OF 8

TITLE MGB INPUT / GIMBAL REMOVAL PULLER SCALE NTS

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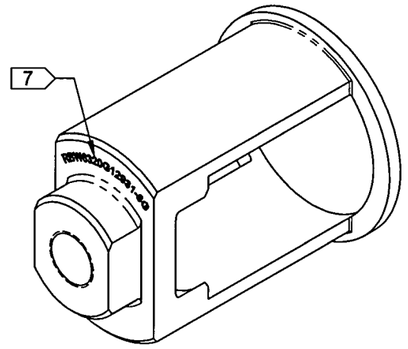

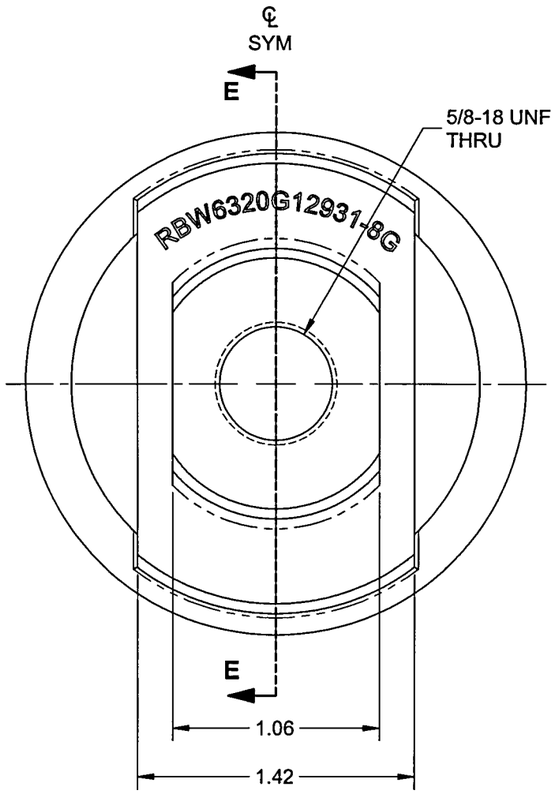

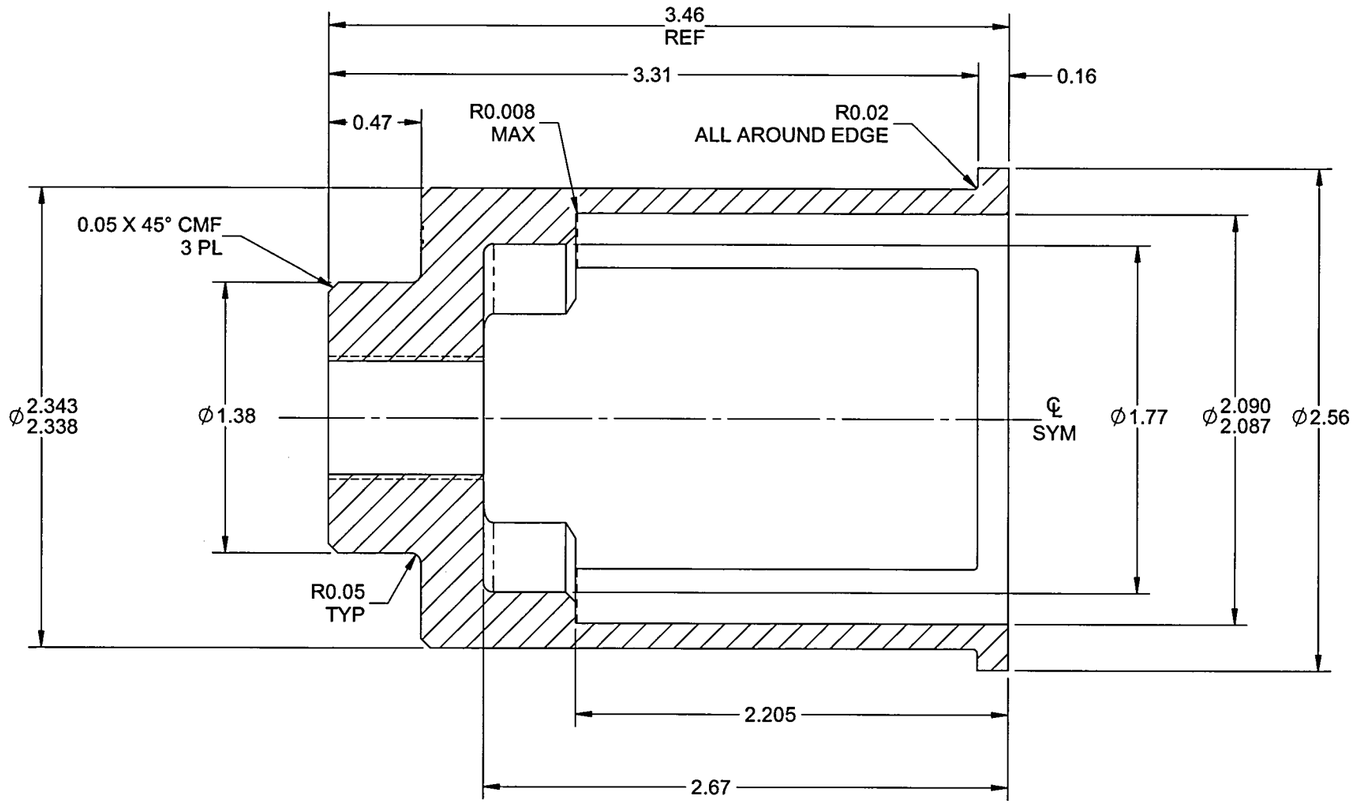

RBW6320G12931-8G-6 EXTRACTOR BODY

SECTION E-E

NOTES:
1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	VM
DRAWN	VM
CHECKED	ML
MFG. APPR.	DP
APPROVED	
DATE	8/28/2018

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART # RBW6320G12931-8G REV. A
SHEET 7 OF 8

TITLE
MGB INPUT / GIMBAL REMOVAL PULLER
SCALE NTS

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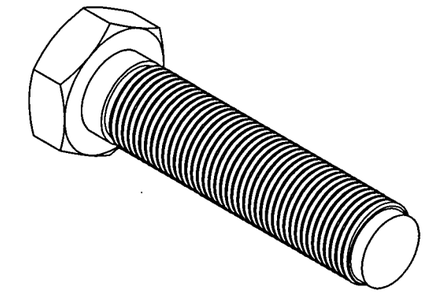
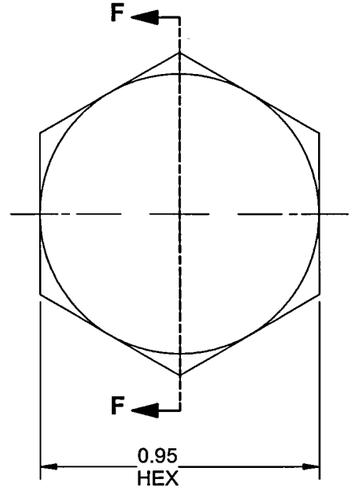
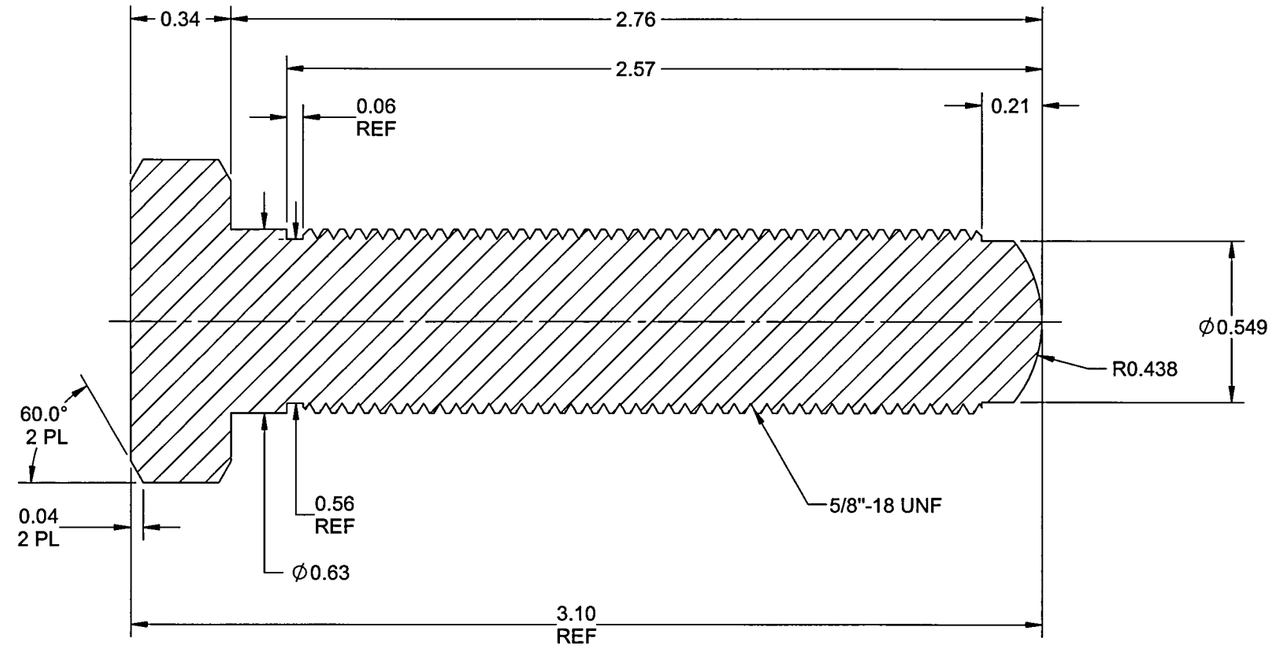




RBW6320G12931-8G-7 SPECIAL BOLT



SECTION F-F

NOTES:
1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	VM
DRAWN	VM
CHECKED	ML
MFG. APPR.	DP
APPROVED	VM
DATE	8/28/2018

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART # RBW6320G12931-8G
REV. A
SHEET 8 OF 8

TITLE
MGB INPUT / GIMBAL REMOVAL PULLER
SCALE NTS

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